

Date: Wednesday, 16/07/2008 10:38:09 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STRUT WELDMENT ASS'Y
<b>Job Number</b> :	40561	<b>Part Number</b> :	D34433
<b>Estimate Number</b> :	10564	<b>Drawing Number</b> :	D3443 REV B
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	16/07/2008	<b>Drawing Revision</b> :	B
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	
<b>First Issue</b> :	1/1	<b>Due Date</b> :	08/08/2008
<b>Previous Run</b> :	35160	<b>Qty:</b>	8
<b>Written By</b> :		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :	<u>JUD 08.7.16</u>		
<b>Comment</b> :	Est Rev: A 05.11.14 New issue EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304R1500	304 round bar 1.500
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**Comment:** Qty.: 0.2500 f(s)/Unit Total: 2.0000 f(s)

M304R1500

M106260

MME 08/07/19

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL  
 1-TURN AS PER FOLIO FA588 & DWG D3443  
 FOLIO REV: AA  
 DWG REV: B

2-DEBURR AS REQUIRED

J.F. 08/07/22

(9)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/07/22

(9)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA588 Rev: B & Dwg D3443 Rev: B

2-Deburr per dwg D3443

M.A. 08/09/14

(8)

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3443-3 PAR #: N/A Fault Category: Prod/Machined <sup>Part</sup> NCR: Yes No DQA: A Date: 08/09/25  
 QA: N/C Closed: A Date: 08/09/25

NCR: <u>40561</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/14	#40	1 of the 3 insert on the 1" seco broke so the part shifted in the collet by more than 100. I changed 1" seco for 1" 5flute rougher	<u>[Signature]</u> 08/09/23	SCRAP and destroy. NO replace extra WAS MADE	<u>D.A.</u> 08/09/23	<u>[Signature]</u> 08/09/23	<u>[Signature]</u> 08/09/23	<u>[Signature]</u> 08/09/23

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 10:38:09 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASSY

Job Number: 40561

Part Number: D34433

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(P)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Y.A

08/09/14

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



(PK) →

Comment: CONVENTIONAL MILLING MACHINE

Drill hole as per Dwg D3443.

mm 08/09/18

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



mm 08/09/18

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/09/22

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 94

AS 08/09/22 x8

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion


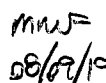
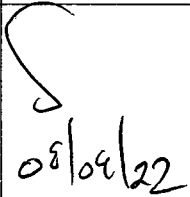
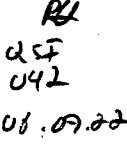



mm 08/09/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/6/18	2 60	operator Driller 0.125" hole on steam in wrong orientation	 dcf 08.09.22	Drill hole in correct location. Leave incorrect hole.	 mms 08/09/19	 08/09/22	 dcf 042 08.09.22	 08/09/19

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order: 40561
Description: Clevis		Part Number: D3443-3
Inspection Dwg: D3443	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.70	+/-0.030	2.730"	✓			
0.95	+/-0.030	.953"	✓			
Ø0.500	+0.000/-0.005	Ø.499"	✓			
20°	+/-0.5°	20°	✓			
R0.450	+/-0.010	R0.450	✓			
Ø0.375	+0.006/-0.001	Ø 0.381	✓			
0.451	+/-0.010	0.454	✓			
0.625	+/-0.010	0.625	✓			
1.53	+/-0.030	1.530	✓			
0.720	+/-0.010	0.715	✓			
0.05 x 45°	+/-0.5°	0.055 x 45°	✓			
45°	+/-0.5°	45°	✓			
1.00	+/-0.030	1.001	✓			
1.125	+/-0.010	1.127	✓			
0.438	+0.005/-0.000	0.438	✓			
R0.050	+/-0.010	R0.050	✓			

Measured by: JF/MA 08/07/22	Audited by: [Signature] 08/09/22	Prototype Approval: N/A
Date: 08/07/22	Date: 08/09/22	Date: N/A
Rev A	Date 06.06.28	Change New Issue
Revised by: KJ/JLM	Approved: [Signature]	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

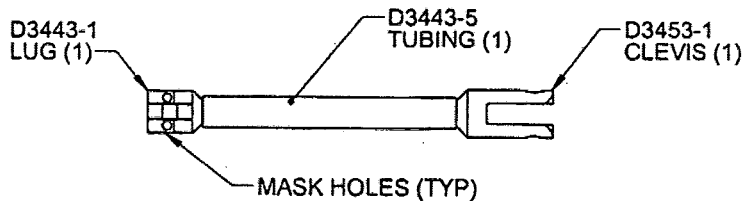
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

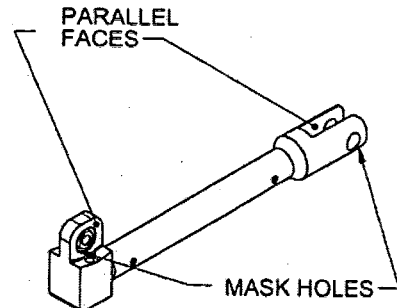
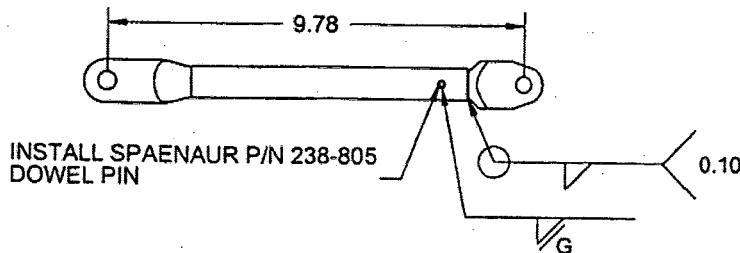
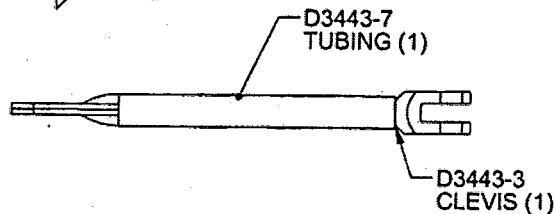
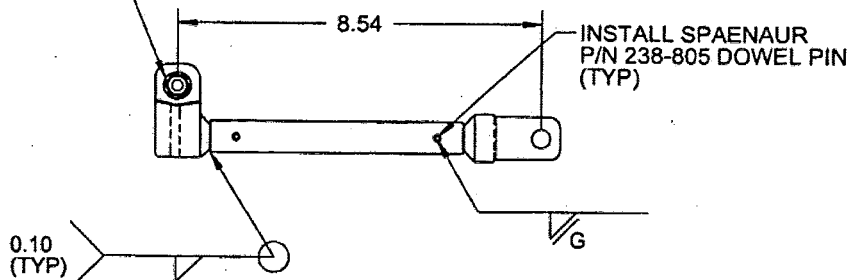
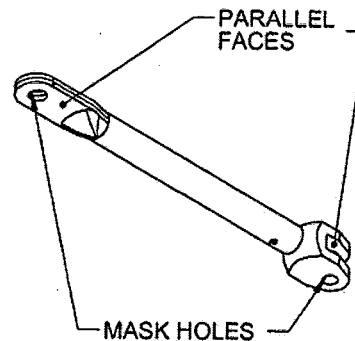
**NOTE:** Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3443</b>	REV. B SHEET 1 OF 3
DATE <b>05.12.05</b>	TITLE <b>STRUT WELDMENT ASSEMBLY</b> SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

**RELEASED**05.12.09 *#*

PRESS FIT McMASTER-CARR P/N 63215K32  
BALL JOINT BEARING AFTER POWDER COAT

**D3443-041****D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

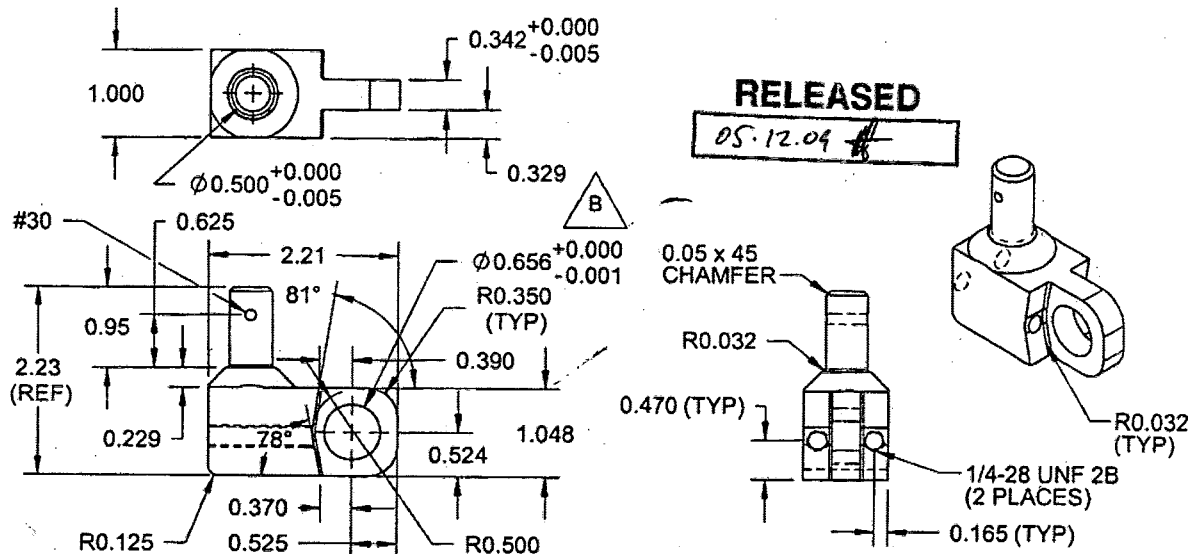
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

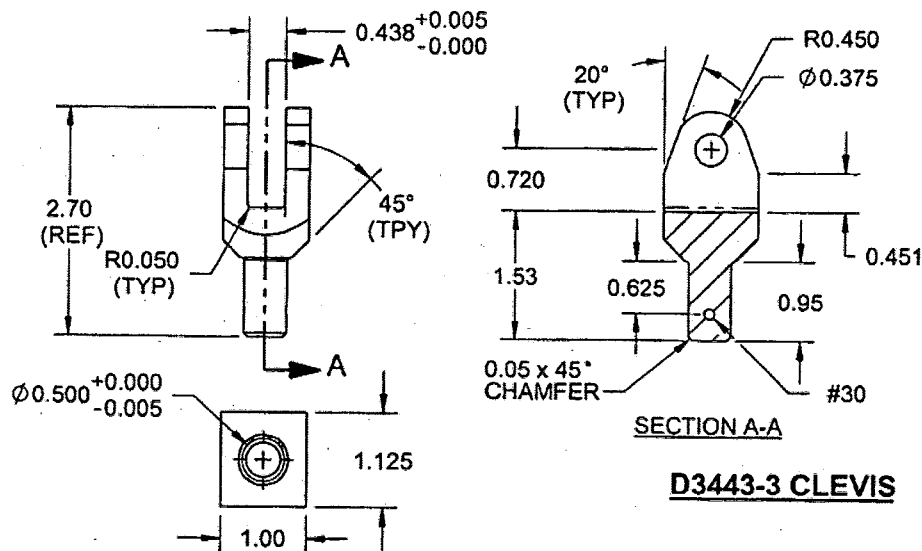


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

**D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

**D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

**GENERAL NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

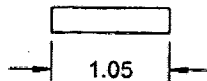
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

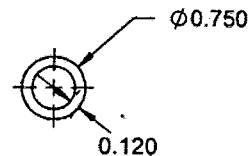
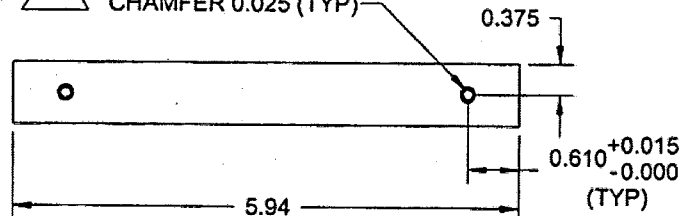
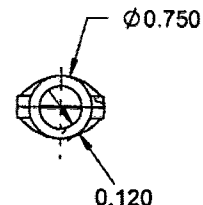
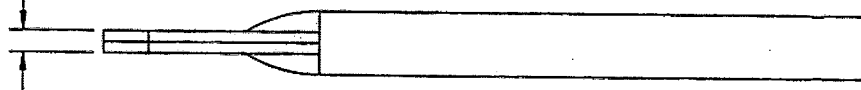
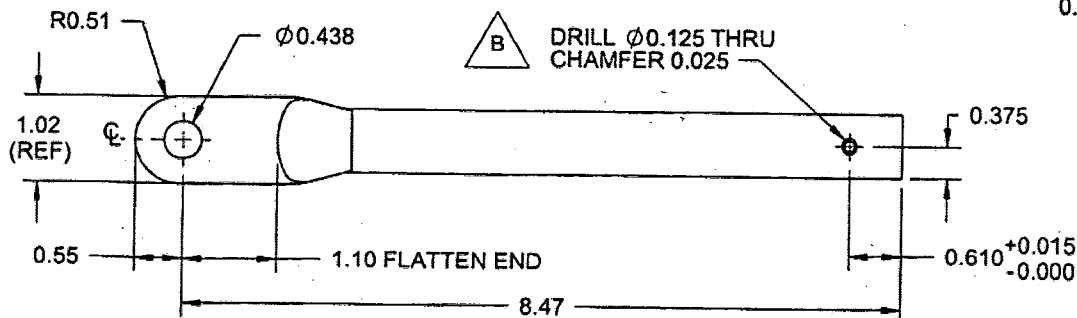
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CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

 $\phi 0.210^{+0.005}_{-0.010}$ **D3443-9 PIN****D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05.12.05

DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025 (TYP)**D3443-5 TUBING** $0.260^{+0.000}_{-0.030}$ DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025**D3443-7 TUBING****D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120) WITHOUT NOTICE
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries